

Work Order ID 66945

Page 1

Thursday, March 03, 2011 8:45:39 AM

Item ID: D3413-1

Accept



Setup Start



Revision ID:

Item Name: Ring

Stop



Start Date: 3/3/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D3413	Rev A	

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

304 . 250 X 4 "

Memo

0.00

B11-3-7

(15)

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

Memo

0.00

B11-3-7

120



QC8- Inspect parts - second check

QC

Quality Control

Memo

0.00

8 uo3/07

(15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66945

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Thursday, March 03, 2011 8:45:40 AM

Item ID: D3413-1

Accept



Setup Start



Revision ID:

Item Name: Ring

Stop



Start Date: 3/3/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop


**Sequence ID/
Work Center ID**

130



Small Fab

Small Fab

**Operation
Description**
Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

1- Deburr and drill hole if required as per dwg D3413 & QSI018 4.1 .

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

3/11/08

0.00

0.00

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M115951

0.00

Memo

8:30

OVEN TEMPERATURE:
900START TIME:
400FINISH TIME:
9:00

B Bl 11-3-9.

(15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 66945

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Thursday, March 03, 2011 8:45:40 AM

Item ID: D3413-1

Accept



Setup Start



Revision ID:

Item Name: Ring

Stop



Start Date: 3/3/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

15 φ 20 11/03/09

170



Packaging

Packaging

Identify as per dwg & Stock Location: 37473

0.00

8/11/03/10 (15)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/3/10 φ

CL 11/03/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, March 03, 2011 8:45:45 AM

Work Order ID: 66945



Parent Item: D3413-1



Parent Item Name: Ring

Start Date: 3/3/2011

Required Date: 3/11/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A□05.09.13□New issue□KJ/JLM
IPP Rev:B Now on Waterjet 07-05-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250X4.000		Purchased	No			100	f	13.4000	0.25	3.157895	4.		

304 BAR .250 x 4.00



Location	Loc Qty	Loc Code
MAT	13.4	
115953	1.4	
116808	12	

116808

13.4 - 7

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	66945
Description: Ring	Part Number:	D3413-1
Inspection Dwg: D3413	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	<u>B</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	11-3-7	Date:	11-4-7	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM <i>[initials]</i>	E

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

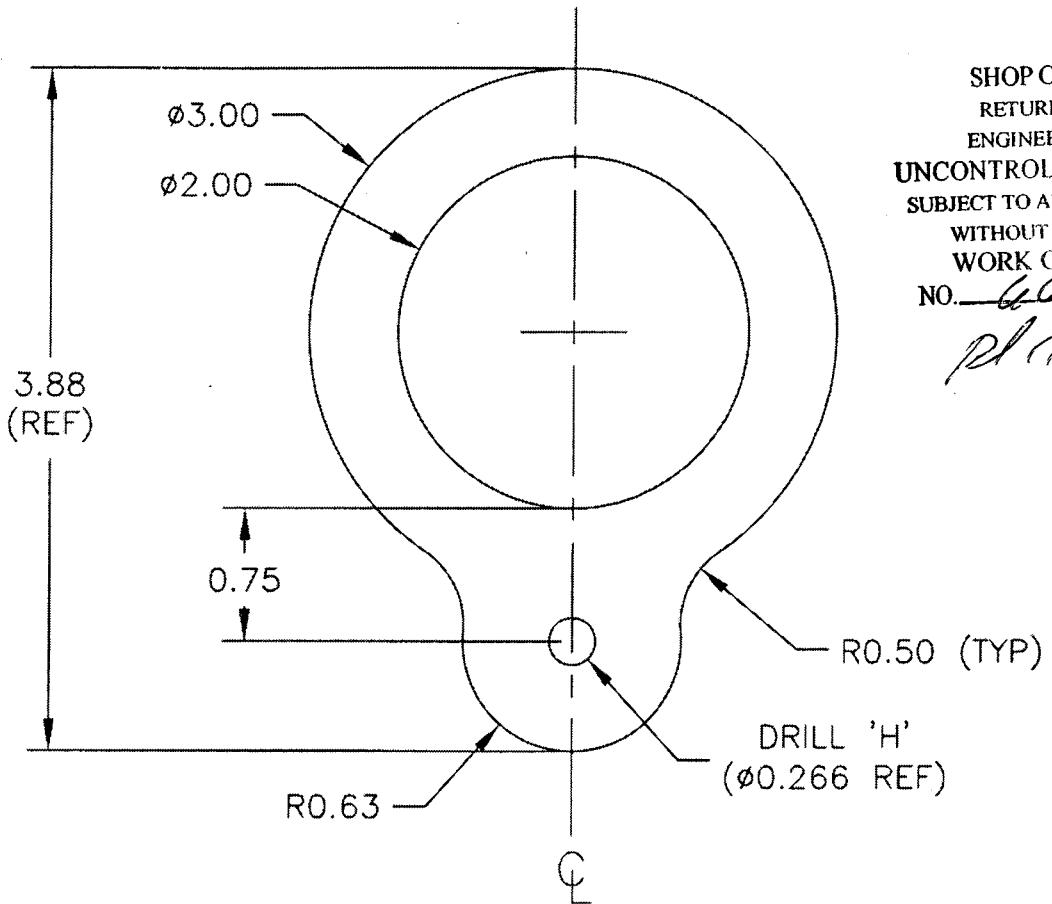
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3413	REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE RING	SCALE 1:1
A	05.03.16	NEW ISSUE	

RELEASED
05-09-06**D3413-1 RING**

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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